

Work Order ID 86879

86879

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July-09-12 9:13:39 AM

Item ID: D2144 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 7/09/12 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-07-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2144	Rev D								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00 12 0 Jm 12-7-13
 FLOW CNC Waterjet 1-Cut as per Dwg D2144 Dwg Rev: D Prog Rev: D 2-
304 .063 Deburr if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 12 0 Jm 12-7-13
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00 DAS 15 8-83 12/10/16 (H2)
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary <i>n/40</i>								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D2144Rev: <i>D</i>								<i>SB 12/03/08</i>
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									<i>12</i>

smf 12.8.28
DAS 16
170829

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating MI 22878	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 12:00 FINISH TIME: 4:00 P OVEN TEMPERATURE: 12:30	0.00 0.00				12 X	Ø		M-F 12/09/26
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	Ø		12-0-26
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: ST005 Memo	0.00 0.00				12			12/09/26 JB

Dart Aerospace Ltd

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/9/28 [Signature]
 MJS 12-09-27

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Picklist Print

July-09-12 9:13:39 AM

Page 1

Work Order ID: 86879

Parent Item: D2144

Start Date: 7/09/12

Required Date: 7/20/12

Parent Item Name: Hinge Bracket

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: D04.05.06ReformatKJ/RF
IPP Rev:E Now on Waterjet 06-10-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			120	sf	317.4900	0.0945	1.134 1.2			
304/316 Sheet .063													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT020		317.49					
						122245		157.49					
						12232i		160					
											<u>122245</u>		

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	<i>94879</i>
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.378"	✓		✓	mmol
3.022	+/-0.010	3.026"	✓		✓	"
2.468	+/-0.010	2.471"	✓		✓	"
1.913	+/-0.010	1.912"	✓		✓	"
1.555	+/-0.010	1.554"	✓		✓	"
4.126	+/-0.010	4.127"	✓		✓	"
3.465	+/-0.010	3.466"	✓		✓	"
0.340	+/-0.010	0.339"	✓		✓	"
0.625	+/-0.010	0.631"	✓		✓	"
1.000	+/-0.010	1.002"	✓		✓	"
1.083	+/-0.010	1.085"	✓		✓	"
1.660	+/-0.010	1.668"	✓		✓	"
2.312	+/-0.010	2.307"	✓		✓	"
2.844	+/-0.010	2.840"	✓		✓	"
3.294	+/-0.010	3.298"	✓		✓	"
Ø0.257	+0.006/-0.001	0.261"	✓		✓	"
Ø0.171	+0.005/-0.001	0.176"	✓		✓	"
Ø0.320	+0.006/-0.001	0.324"	✓		✓	"
0.354	+/-0.010	0.352"	✓		✓	"
0.063	+/-0.010	0.058"	✓		✓	"

Measured by:	<i>Jm</i>	Audited by:	<i>DAS</i>	Prototype Approval:	N/A
Date:	<i>12-7-13</i>	Date:	<i>12/10/16</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	<i>[Signature]</i>

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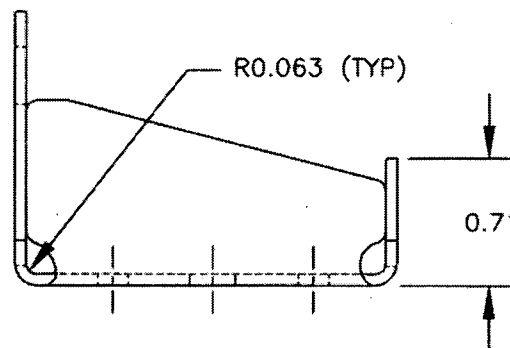
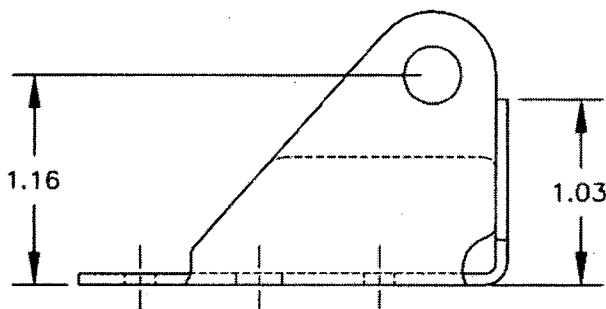
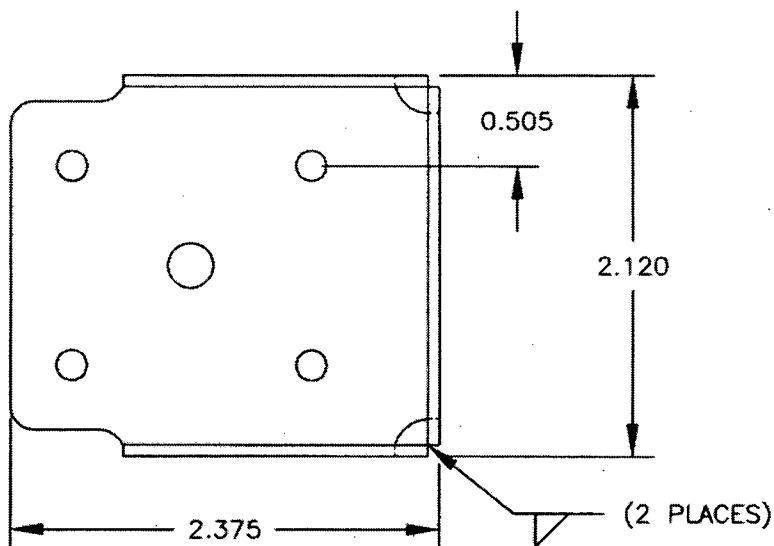
NOTE: Date & initial all entries



RELEASED
98.10.15 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 8879

11207-10



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
BW	KE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
MA	KE	02144	
DATE	TITLE	SCALE	
98.10.08	HINGE BRACKET	1:1	
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	

W/O:		WORK ORDER CHANGES					
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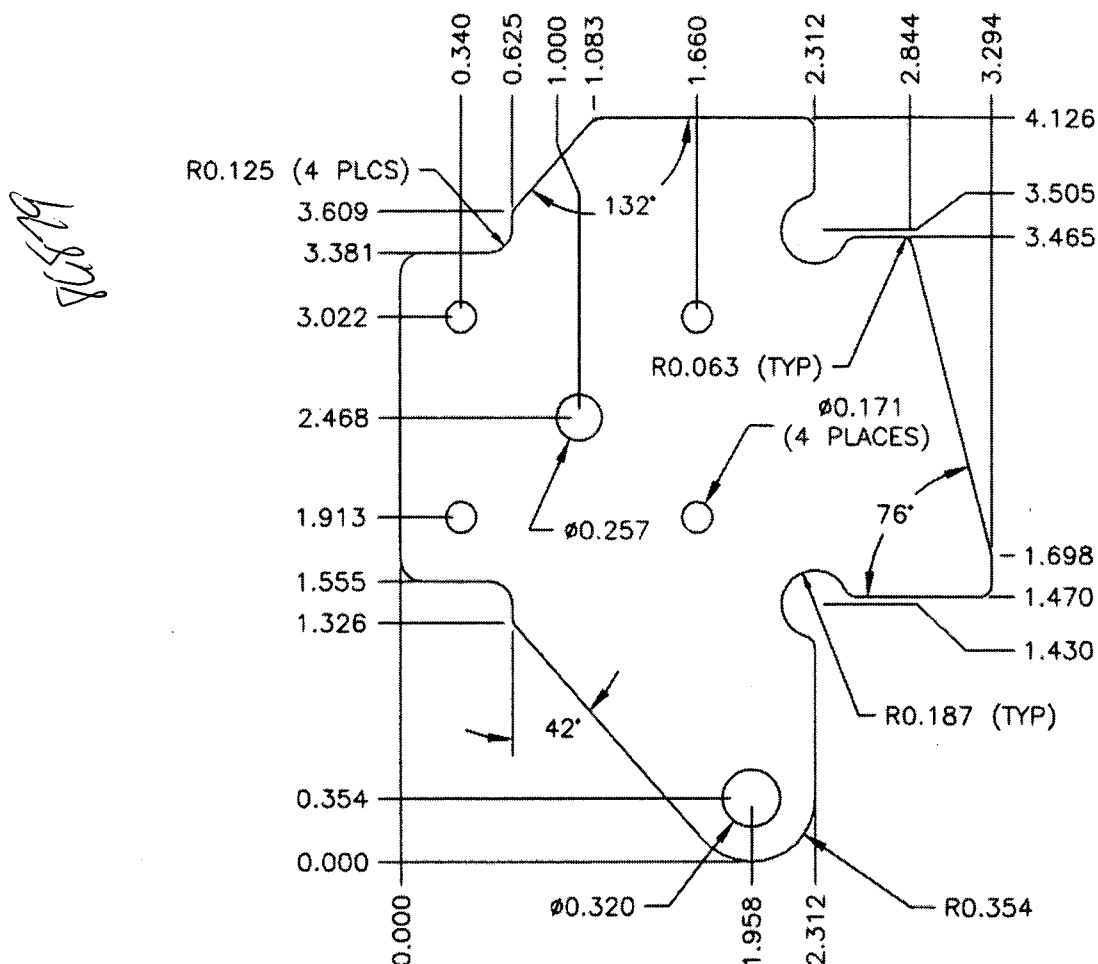
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NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15 KB



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
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